

# Work Order ID 66247

February 8, 2011 10:05:22 AM



Page 1

Item ID: D3278-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 2/08/11 Start Qty: 40.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/02/08 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3278	Rev C
-------	-------

100

0.00



BAND SAW

B.A 11/03/08

40

φ

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 1.00" x 2.550" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

B.A 11/03/09

40

φ

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FA405 and Dwg D3278□2- Deburr and Tumble□Identify as D3278-1

120

0.00



QC2- Inspect parts off machine FAI/FAIB

B.A 11/03/09

40

φ

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 66247

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Item Name: Support

Start Date: 2/08/11

Start Qty: 40.00



Cust Item ID:

Required Date: 2/22/11

Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*MR 11/03/10*

*40*

*0*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*A.E*

*11-03-11*

*(40)*

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

*M115951*

START TIME:

*8:55*

OVEN TEMPERATURE:

*320* FINISH TIME:

*8:25*

*40*

*11-3-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66247**

Page 3

February 8, 2011 10:05:22 AM

Item ID: D3278-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 2/08/11 Start Qty: 40.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

40 d J 11/03/15

170

Identify as per dwg & Stock Location *Small feet*

0.00



Packaging

Memo

0.00

Packaging

*Coconut*11/3/15 *(40)*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/15 *J*

CL 11/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 8, 2011 10:05:22 AM

Page 1

Work Order ID: 66247



Parent Item: D3278-1



Parent Item Name: Support

Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐A ☐04.04.19 ☐New issue ☐KJ/JLM ☐  
IPP B 07.09.06 rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	53.4303	0.2337	9.84			



6061-T6 Bar 1.00 x 2.00

Location	Loc Qty	Loc Code
MAT	51.972	
112567	0	
114415	3.75	
115045	3.902	
115952	40	
116623	4.32	
MAT03	1.4583	
112567	1.4583	

6.3734 ft  
3.4666 ft

J.A 11/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

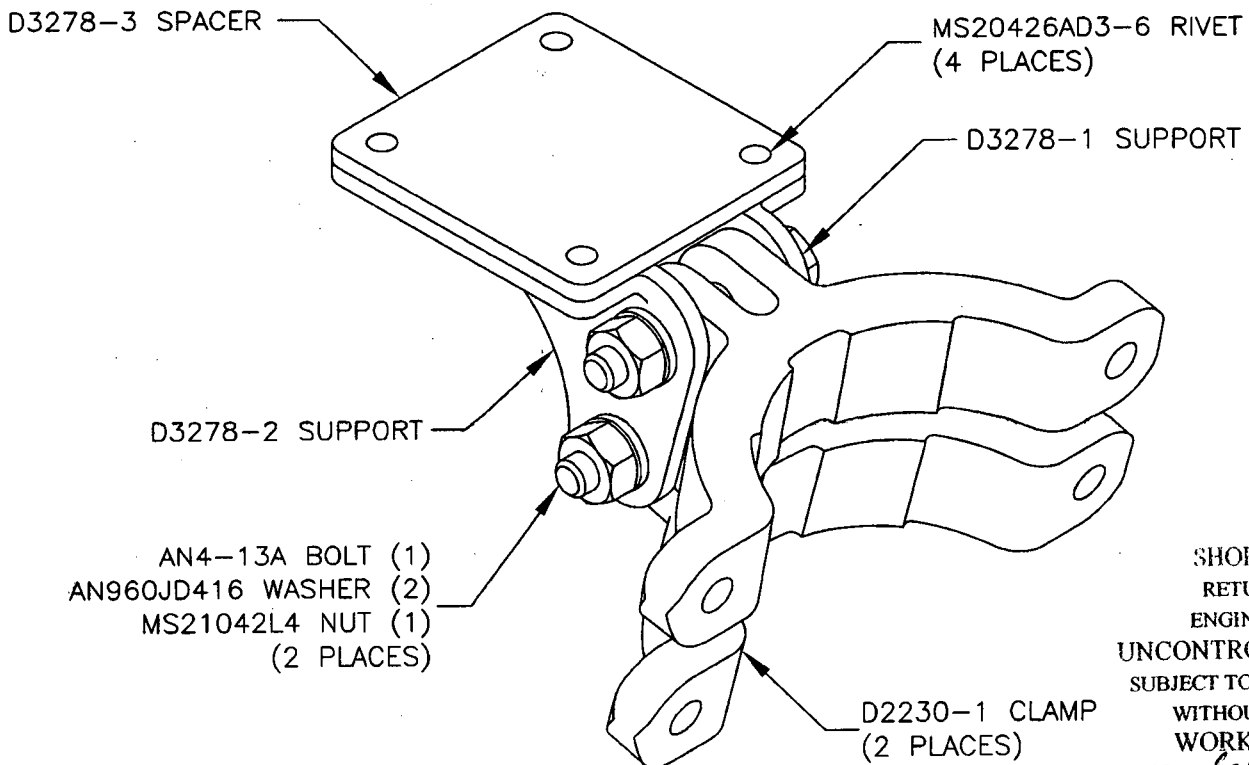
**NOTE:** Date & initial all entries



**DART****RELEASED**  
07-08-08

DESIGN 92	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

## D3278-041 SUPPORT ASSEMBLY



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WITHOUT NOTICE  
WORK ORDER  
NO. 66247

CZ1102108

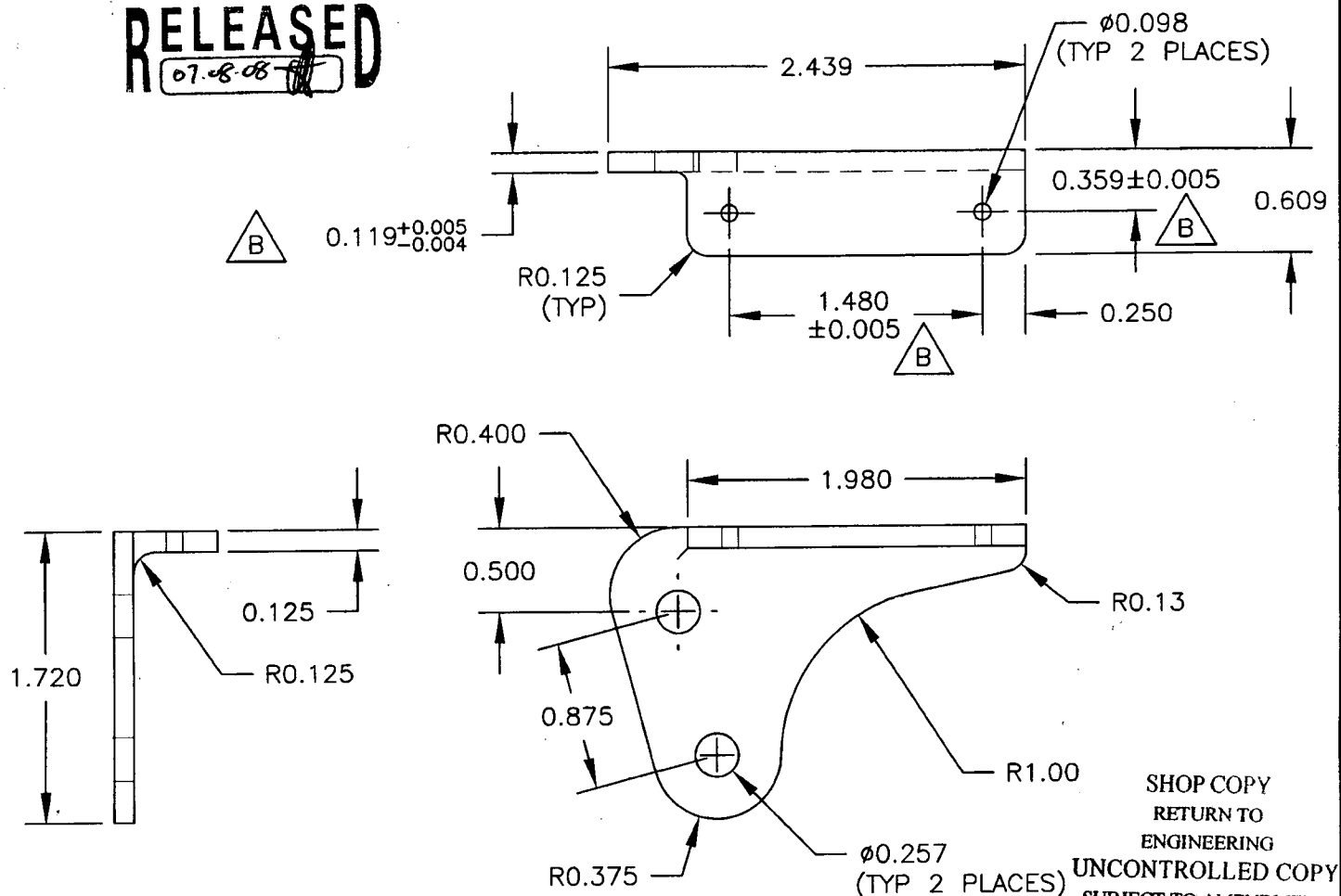
Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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**DART**

DESIGN <i>qp</i>	DRAWN BY <i>bc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>3</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

**RELEASED**  
07.8.08

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WORK ORDER  
NO. 66247

**D3278-1 SUPPORT (SHOWN)**  
**D3278-2 SUPPORT (OPPOSITE)**

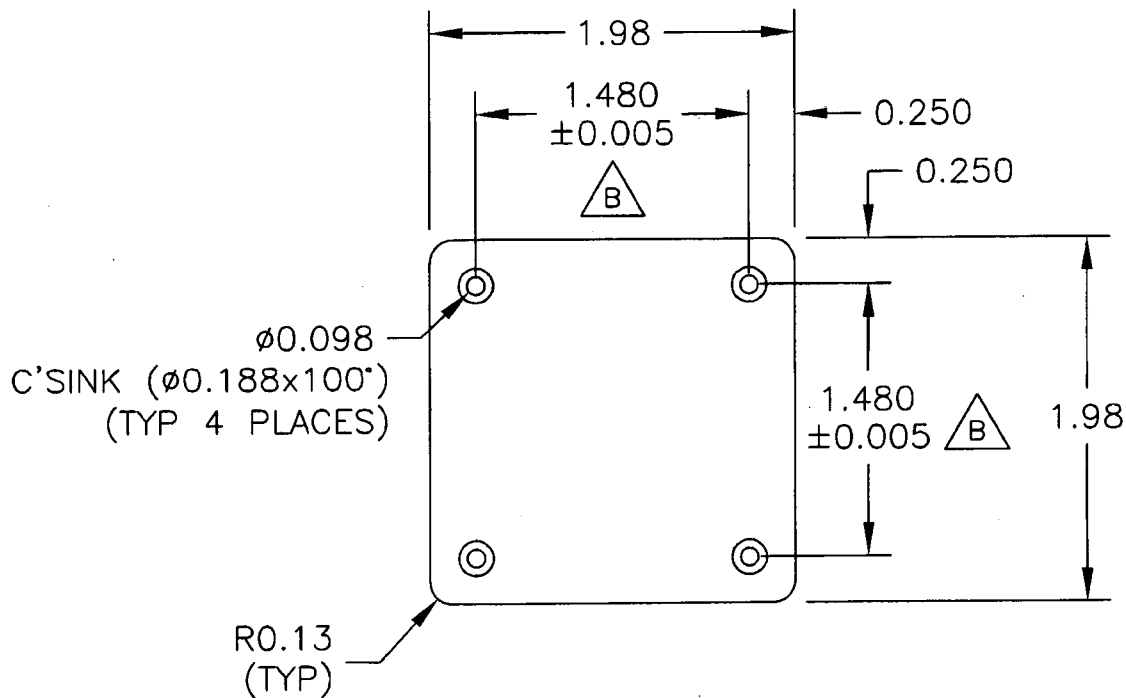
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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**DART**

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08

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WITHOUT NOTICE  
WORK ORDER  
NO. 66247

**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	66247
<b>Description:</b> Support		<b>Part Number:</b>	D3278-1
<b>Inspection Dwg:</b> D3278 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø 0.100	✓		Vern	GA-01
0.359	+/-0.005	0.359	✓		"	"
0.609	+/-0.010	0.611	✓		"	"
0.250	+/-0.010	0.250	✓		"	"
1.480	+/-0.005	1.480	✓		"	"
R0.125	+/-0.010	R0.125	✓		R-6	ref.
0.119	+0.005/-0.004	0.120	✓		Vern	GA-01
2.439	+/-0.010	2.440	✓		"	"
1.980	+/-0.010	1.980	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-6	ref.
Ø0.257	+0.005/-0.000	Ø0.258	✓		Vern	GA-01
R0.375	+/-0.010	R0.375	✓		R-6	ref.
0.875	+/-0.010	0.875	✓		Vern	GA-01
0.500	+/-0.010	0.499	✓		"	"
R0.400	+/-0.010	R0.400	✓		R-6	ref.
R1.00	+/-0.030	R1.000	✓		"	"
1.720	+/-0.010	1.720	✓		Vern	GA-01
R0.125	+/-0.010	R0.125	✓		R-6	ref.
0.125	+/-0.010	0.127	✓		Vern	GA-01

<b>Measured by:</b>	A.A
<b>Date:</b>	11/03/09

<b>Audited by:</b>	anf
<b>Date:</b>	11/03/10

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue      P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	EF

